

Work Order ID 70516

Friday, June 10, 2011 11:26:37 AM



Page 1

Item ID: D4273-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly, RH

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 11-06-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4273

D

D4279

B

100

Weld per dwg A/R S.S. rod Batch: *M115778* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-
N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHET MESH IS
INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on
basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear
fasteners holes on the ends (D4279-5/-9)

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

11.06.17

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

QC 11.06.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

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Item Name: Basket Base Assembly, RH

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Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 6/10/20

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 6/10/20

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D4273-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: Basket Base Assembly, RH
Start Date: 6/10/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 6/15/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M116 964</i> Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: START TIME: <i>1:05</i> OVEN TEMPERATURE: <i>100°</i> FINISH TIME: <i>1:05</i> ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<i>1</i>	<i>BL</i>	<i>11-6-20</i>	
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>1</i>	<i>QC 11/06/21</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Item ID: D4273-042

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Revision ID:

Stop



Item Name: Basket Base Assembly, RH

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

W/O

0.00

Packaging

B 70507

ES 11/06/21 Q

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/21 MF
11-06-21

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NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 11:26:44 AM

Page 1

Work Order ID: 70516

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC
 11.01.20 AS PER DWG REV.C DD verf:EC
 AS PER DWG REV.D DD verf:EC
 IPP Rev:B
 IPP Rev:C 11.03.03

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304EX0.75-16F		Purchased	No			100	sf	662.4032	26.195	26.195			
Expanded Metal Flat SS													

Location	Loc Qty	Loc Code
MAT	57.2107	
117708	57.2107	
WA	605.1925	
115012	102	
117197	167.1584	
117455	16.0341	
117896	320	

D3913-1		Manufactured	No			100	Each	7.0000	1	1			
Rib													

Location	Loc Qty	Loc Code
WA	5	
69260	2	
70346	3	
WA006	2	
69427	2	

W/O:		WORK ORDER CHANGES					
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Friday, June 10, 2011 11:26:44 AM

Work Order ID: 70516

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 6/10/2011

Required Date: 6/15/2011


Start Qty: 1.00

Required Qty: 1.00

D3913-3

 Rib

Manufactured No 100 Each 6.0000 1 1

 SAD 11-06-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	2	
69160	2	
WA006	4	
69259	1	
69646	3	

①

D3913-9

 Hinge Rib

Manufactured No 100 Each 6.0000 1 1

 SAD 11-06-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	3	
70336	3	
WA006	3	
70138	3	

①

D3916-5

 Light Rib

Manufactured No 100 Each 3.0000 3 3

 SAD 11-06-14


<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA006	3	
69156	3	

③

D4017-7

 Rib

Manufactured No 100 Each 1.0000 1 1

 SAD 11-06-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	1	
69009	1	

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 70516

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D4277-3	Manufactured	No	100	Each	0.0000	1	1		
Rib									
D4277-5	Manufactured	No	100	Each	0.0000	2	2		
Rib									
D4277-9	Manufactured	No	100	Each	0.0000	1	1		
Rib									
D4277-19	Manufactured	No	100	Each	1.0000	1	1		
Rib									

B70739

SAD 11-06-14

B70740

SAD 11-06-14

B70741

SAD 11-06-14

SAD 11-08-14

Location

Loc Qty

Loc Code

WA

65683

D4278-041	Manufactured	No	100	Each	0.0000	1	1		
Upper Rib Assembly-Hoop									
D4278-045	Manufactured	No	100	Each	0.0000	2	2		
Rib Assembly, Fwd Cham									
D4278-047	Manufactured	No	100	Each	0.0000	1	1		
Upper Rib Assembly-Straight									
D4306-1	Manufactured	No	100	Each	0.0000	1	1		
Rib									
D4306-044	Manufactured	No	100	Each	0.0000	1	1		
Rib Assembly, RH									

B70742

①

①

11.06.15

B70743

②

11.06.15

~~B70742~~ B70744

SAD 11-06-14

B70745

SAD 11-06-14

B70746 ①

② 11.06.15

Friday, June 10, 2011 11:26:45 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Work Order ID: 70516

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D4306-045 Manufactured No

100 Each 0.0000

1 1



B70747



SAD 11-06-14

Rib Assembly

D2581 Manufactured No

100 Each 74.0000

2 2



SAD 11-06-14

Mounting Bracket

Location

Loc Qty

Loc Code

WA

74

68964

6

69258

28

69739

40

2

D3913-15 Manufactured No

100 Each 14.0000

1 1



SAD 11-06-14

Wide Handle Plate

Location

Loc Qty

Loc Code

WA

8

69158

4

69647

4

WA005

6

69012

6

1

D4016-1 Manufactured No

100 Each 16.0000

3 3



SAD 11-06-14

Hinge Half, Base

Location

Loc Qty

Loc Code

WA

16

66418

0

68426

16

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 70516

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No 100 Each 54.0000 3 3

 Handle Plate

SAD 11-06-14

Location	Loc Qty	Loc Code
WA	54	
69518	14	
69777	40	

3

✓ D4279-3 Manufactured No 100 Each 0.0000 1 1

 Mesh, Chamfer

B70748

①

11.06.17

D4279-5 Manufactured No 100 Each 1.0000 1 1

 End Mesh, Basket

SAD 11-06-17

Location	Loc Qty	Loc Code
WA	1	
68051	1	

B70916

①

✓ D4279-7 Manufactured No 100 Each 0.0000 2 2

 End Mesh, Basket

B70749

②

11.06.17

✓ D4279-9 Manufactured No 100 Each 1.0000 1 1

 End Mesh, Basket

B70840

①

11.06.17

Location	Loc Qty	Loc Code
WA	1	
63790	1	

✓ D4279-11 Manufactured No 100 Each 0.0000 1 1

 Mesh, Base

B70750

11.06.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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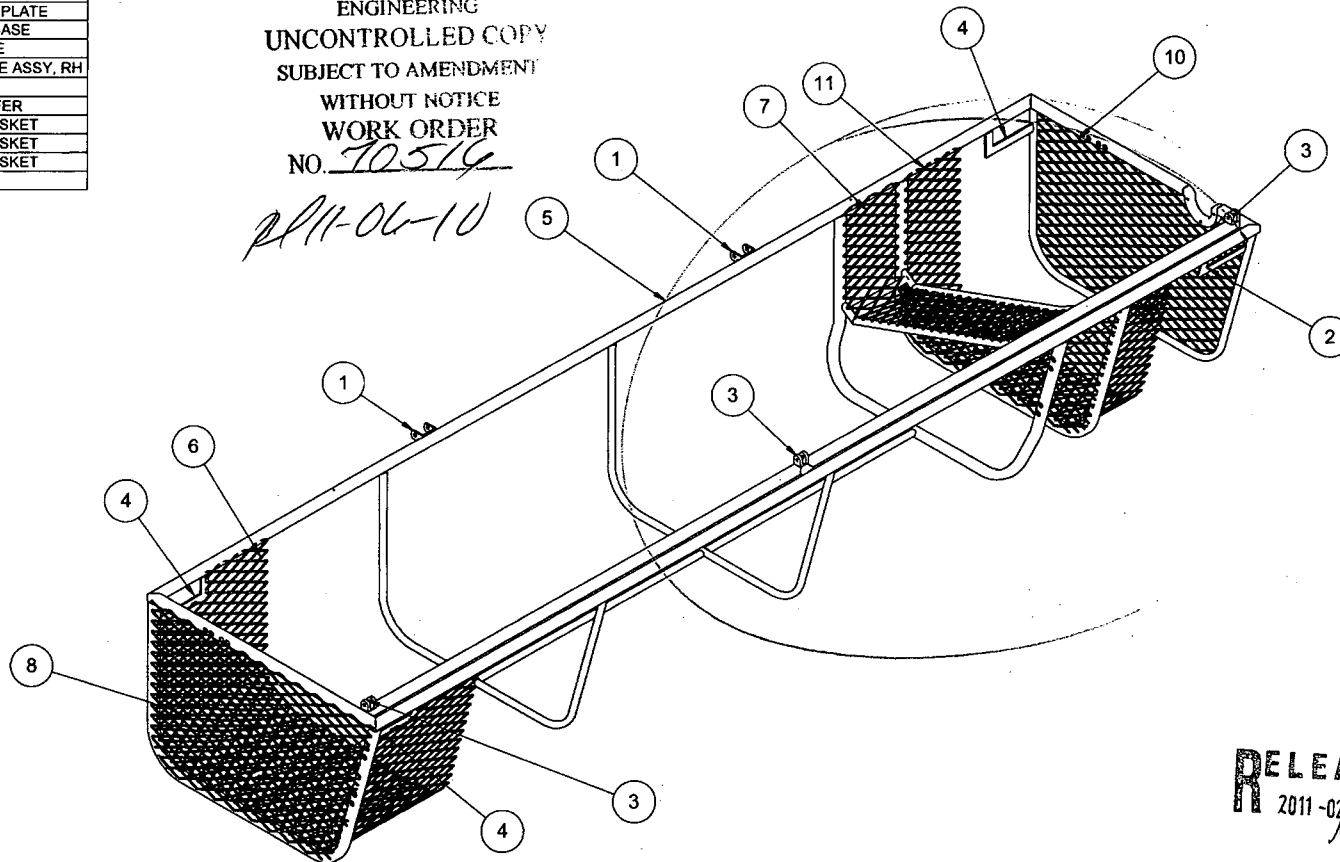
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70516

211-06-10



D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

RELEASED
2011-02-24
W

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4273	SHEET 6 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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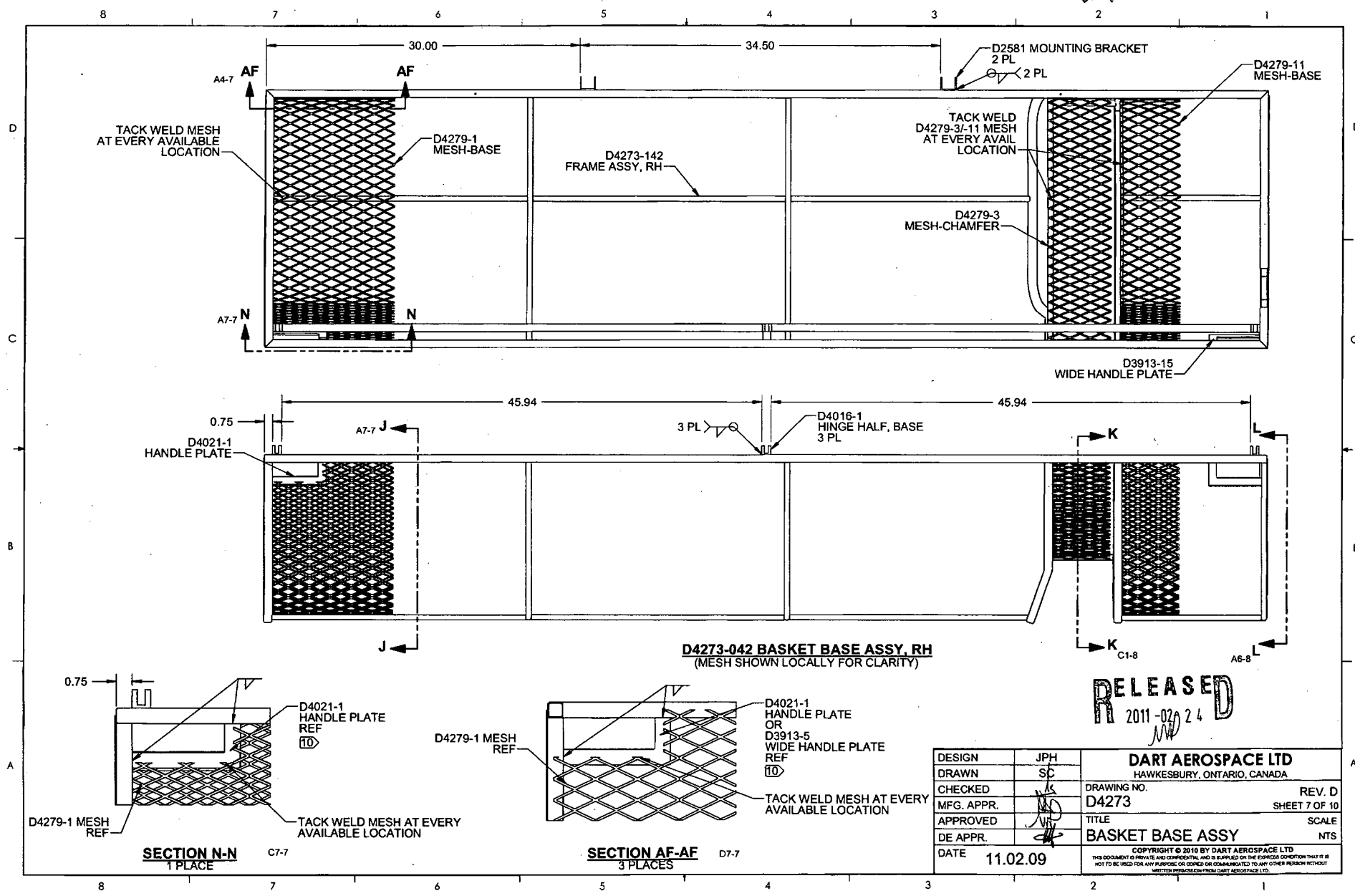
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ULO 70514



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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D4273	SHEET 7 OF 10
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSY	NTS
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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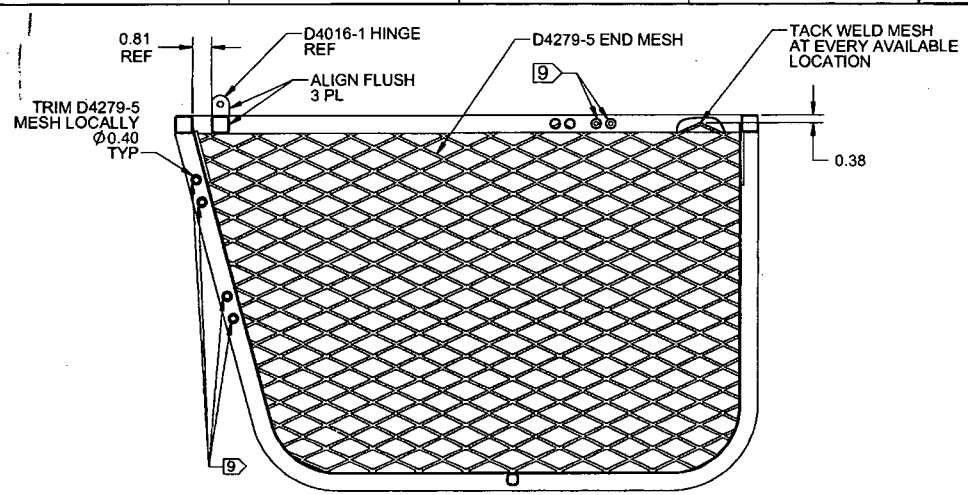
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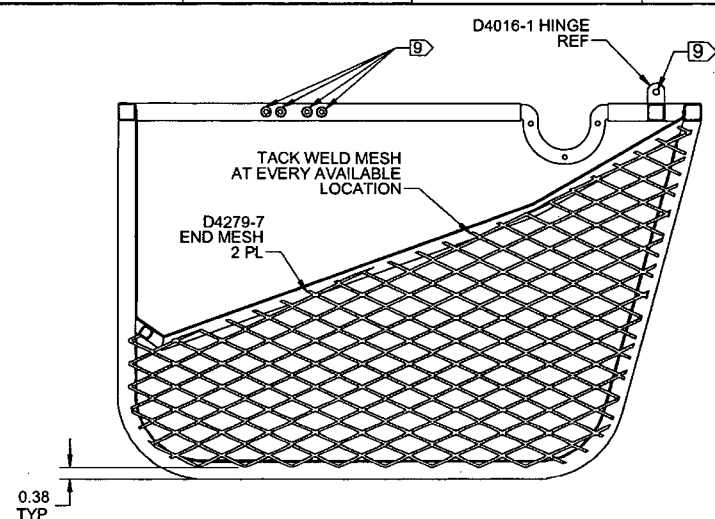
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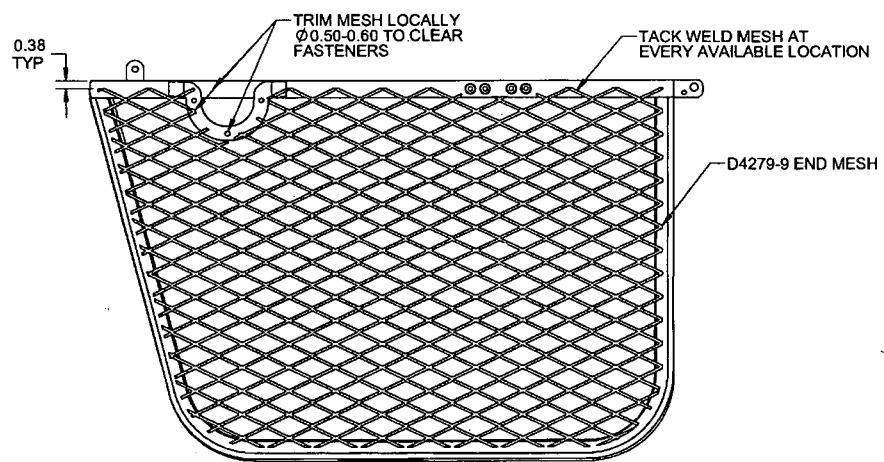
aka 90516



SECTION J-J C6-7



SECTION K-K B2-7
(MESH SHOWN LOCALLY FOR CLARITY)



SECTION L-L B1-7
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
R 2011-02-12 4 D

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 8 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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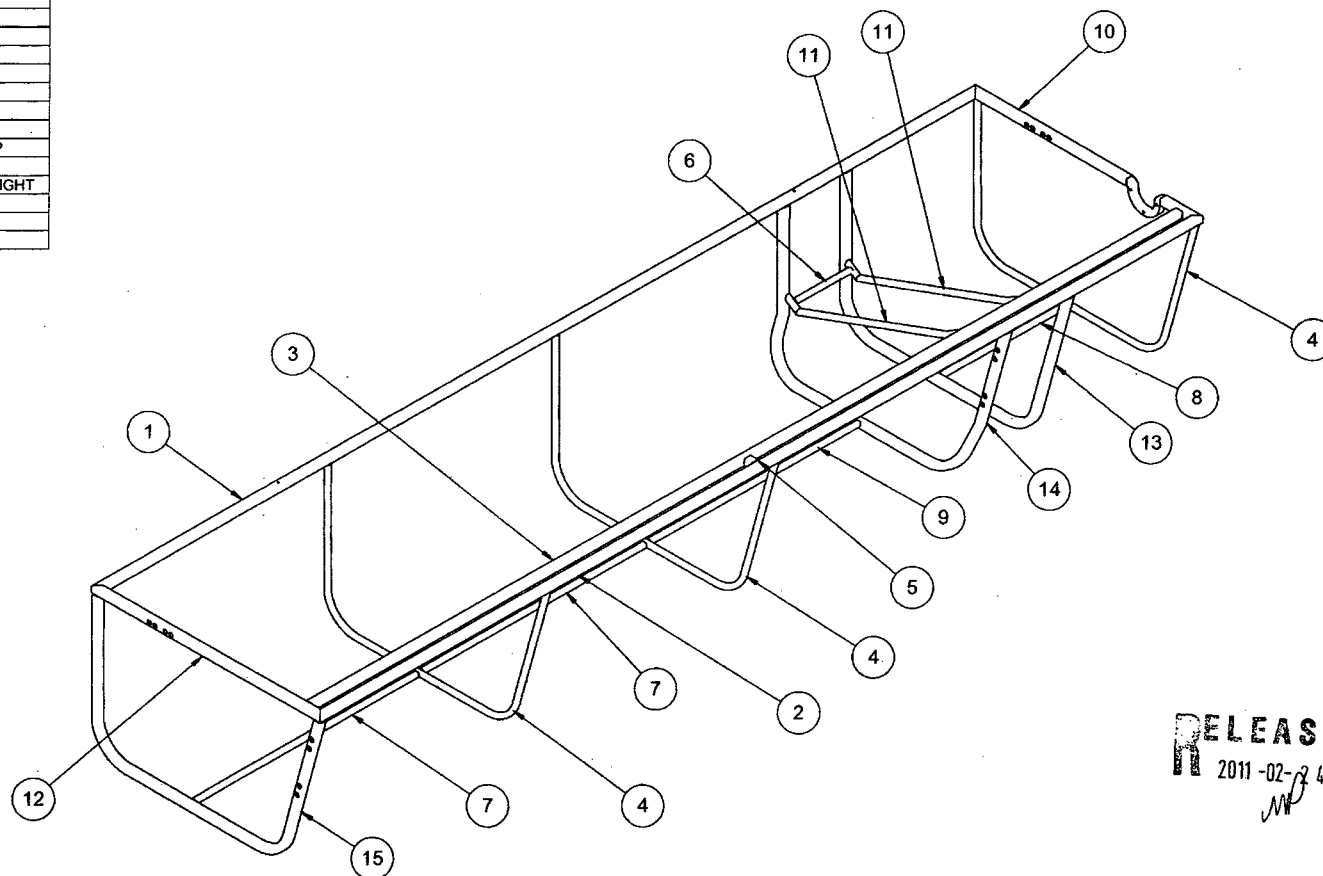
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NOTE: Date & initial all entries

21070516

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY



D4273-142 BASKET FRAME ASSY, RH

RELEASED
R 2011-02-24
MP

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 9 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

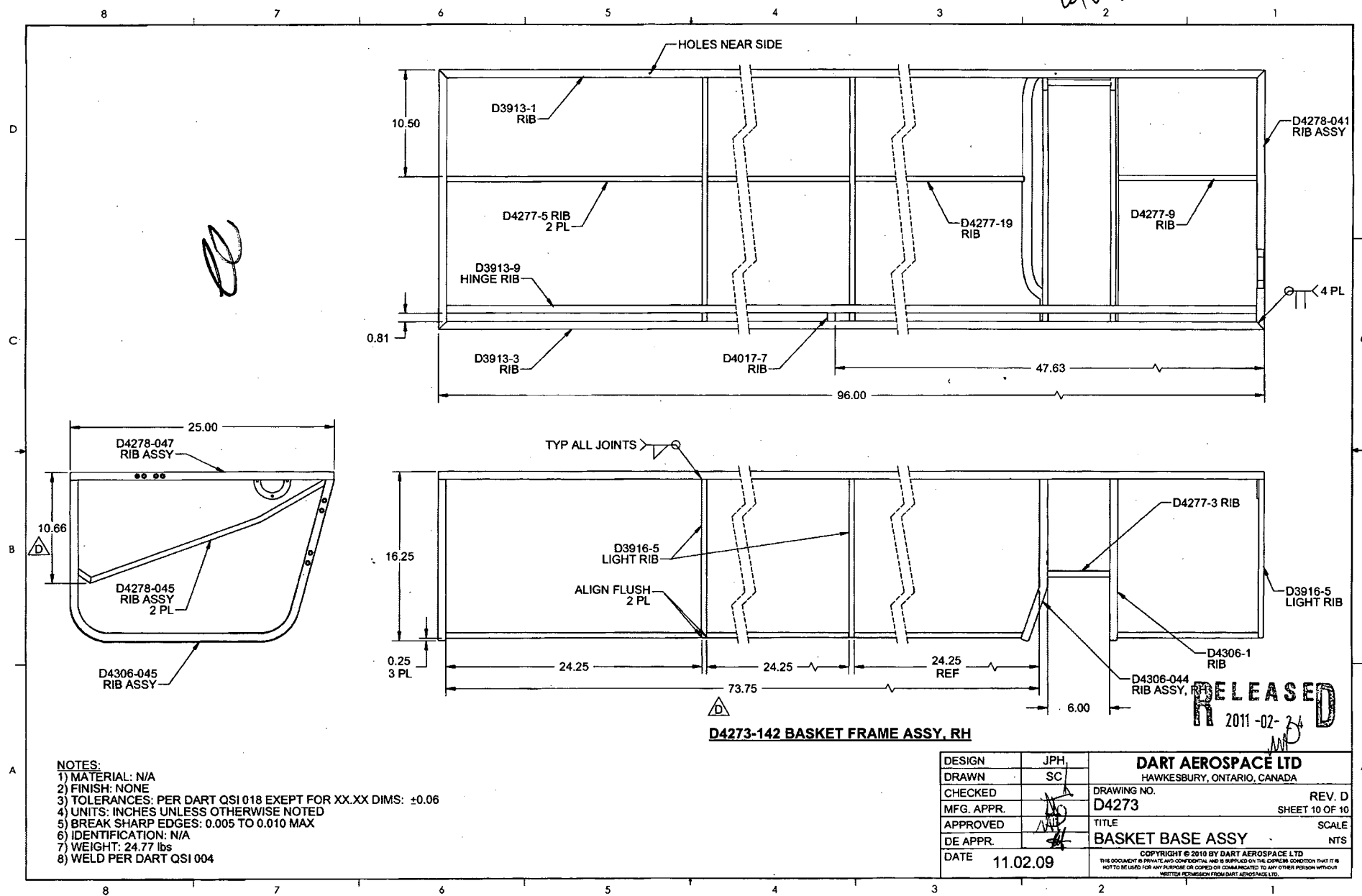
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 70516



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 24.77 lbs
- 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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